

Date: Monday, 11/19/2007 4:04:17 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL ASSEMBLY
Job Number	: 35853		
Estimate Number	: 10504		
P.O. Number	: N/A	Part Number	: D3204041
This Issue	: 11/19/2007 S.O. No. : N/A	Drawing Number	: D3204 REV. A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A1
Previous Run	: 34237	Material	: N/A
Written By	:	Due Date	: 12/5/2007 Qty: 4 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est:C 05.08.11 Added Step 25 KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32041 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube

Pick:

Qty	Part Number	Description	Batch
1	D3204-1	Tube	B23928 → 4

[Signature] 07/11/23

2.0 D32043 Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
1	D3204-3	Arm	B32840 → 3

[Signature] 07/11/23

3.0 D32045 Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
1	D3204-5	Arm	B30896 → 1

[Signature] 07/11/23

4.0 D32049 Pedal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pedal

Pick:

Qty	Part Number	Description	Batch
1	D3204-9	Pedal	B30897 → 1

[Signature] 07/11/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 35853

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D320411

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Plate

Pick:

Qty Part Number Description
1 D3204-11 Plate

Batch

B32839

07/12/18

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. ✓

2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. ✓

3- Use JB weld compound to plug the hole after assembly. ✓

4- Grind JB weld flush after it is cured. ✓

Identify as D3204-041 ✓

07/12/19

4x

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-12-19 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/20 (4)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07/12/27 (4)

10.0

POWDER COATING

POWDER COATING



M105642



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Cover holes for bushing

07/12/27 (4)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

* D3204-13 Gusset
- 8 morceaw

Qty 2

Batch: B35970

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/01/03

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:04:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 35853

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D32047

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
2	D3204-7	Bushing	<u>24722</u>

7/12/27 50 (4x)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D3204-7 bushing as shown in Dwg D3204

SAD 07-12-27 (3x)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/12/26 (3)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/12/26 (3)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

HD 08/01/03 (3)

Job Completion



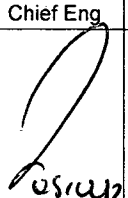
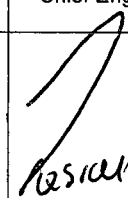
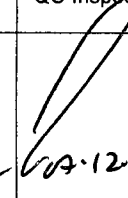
2008/1/3
W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

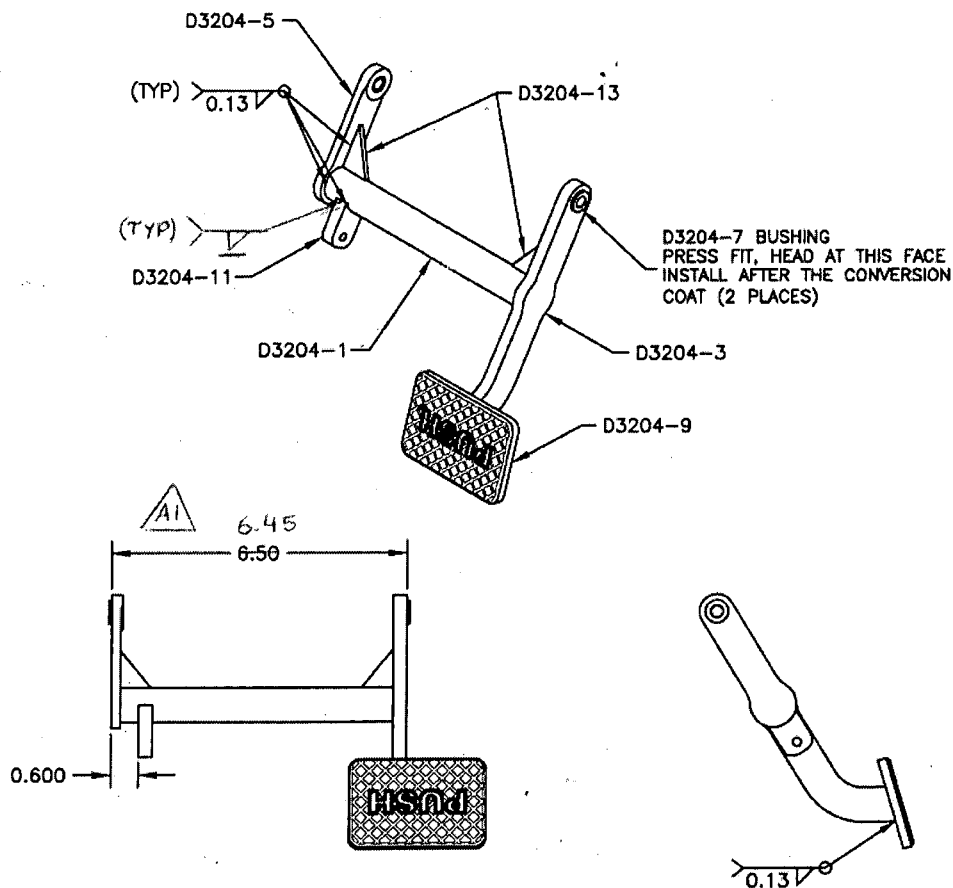
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/26	13.0	Qty 7X the D3204-3 is scrap. the hole for the bushing was oval, and left a gap at the top: bottom of the bushing, and tore the material on the edges.		scrap: destroy. qty 7 re-stock D3204-7 bushings for this ass'y.	SAD 07-12-27	SD 07/12/26		
		2-C: operator error: machining						

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125" LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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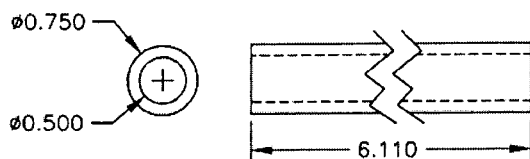
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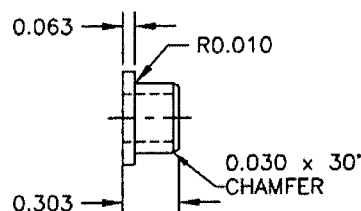


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

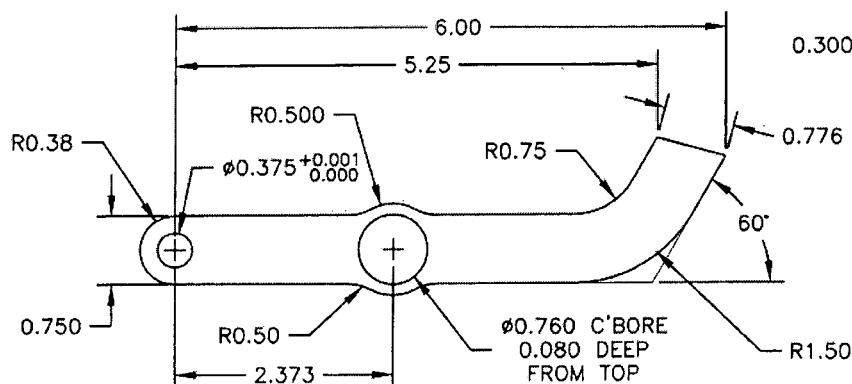
RELEASED
04.04.05 *[Signature]*



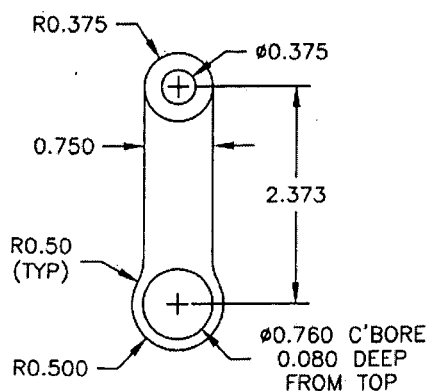
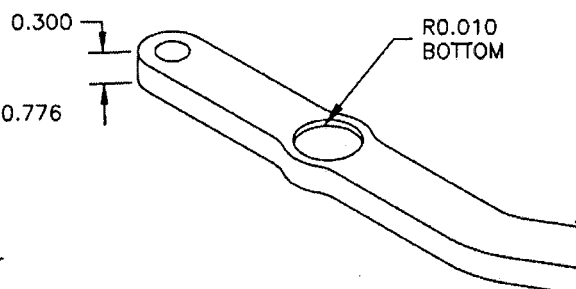
2 D3204-1 TUBE
SCALE 1:2



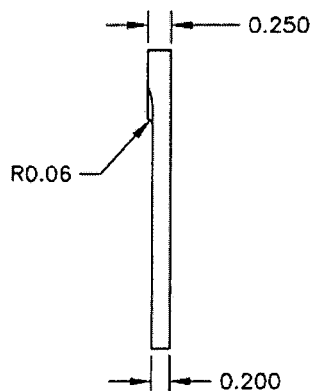
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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